

Date: Tuesday, 10/2/2007 10:44:01 AM
 User: Kim Johnston

Process Sheet

44

Customer	: CU-DAR001 Dart Helicopters Services		Drawing Name	: WEARPAD	
Job Number	: 34943		Part Number	: D35371	
Estimate Number	: 12712		Drawing Number	: D3537 REV C	
P.O. Number	:		Project Number	: N/A	
This Issue	: 10/2/2007	S.O. No. :	Drawing Revision	: C	
Prsht Rev.	: NC		Material	:	
First Issue	: / /	Type :	Due Date	: 10/30/2007	
Previous Run	: 34282		Qty:	125 100 Um: Each	
Written By	: <u>JL</u> 07 10, 02		Comment	: Est Rev: A New Issue 07-02-14 JLM	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	M304S16GA	304/316 .063 Sheet 10.0076
Comment: Qty.: 0.0788 sf(s)/Unit Total : 7.8750 sf(s) M304S16GA .063" 304 SS SHEET Batch: <u>10S 130</u> <u>1B 07-10-9</u>		
2.0	WATER JET	FLOW WATER JET
Comment: FLOW WATER JET 1-Cut as per Dwg D3537 Dwg Rev: <u>C</u> <u>1B 07-10-9</u> Prog Rev: <u>C</u>		
2-Deburr if necessary <u>1B 07-10-9</u>		
3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE <u>1B 07-10-9</u>
Comment: INSPECT PARTS AS THEY COME OFF MACHINE		
4.0	QC8	SECOND CHECK
Comment: SECOND CHECK <u>Er 07/10/10</u> <u>X/125</u> <u>Coukes</u>		
5.0	BRAKE NC	NC BRAKE
Comment: NC BRAKE 1-Form as per Dwg D3537 on CNC brake using Jigs DT 8261 and DT 8326. 2-Identify as D3537-1		
		<u>SP 07/10/11</u> <u>125</u>

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Tuesday, 10/2/2007 10:44:01 AM
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Job Number:



Seq. #: Machine Or Operation:

Description :

6.0 LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

Qty Description Batch
A/R 2059B Hardcoat *m10599/M10 60³⁶ FC/188*

1-Weld as per Dwg D35371 using Jig DT 8210

2-Remove any weld that penetrated through Wearpadif necessary

07/10/26

125x

7.0 QC9

VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

07-10-29 125

8.0 QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

G 07/10/29 125

9.0 POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat Grey Sandtex (Ref: 4.3.5.6) as per QSI 005 4.3

125

10.0 QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

M-j 07/10/31

11.0 PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: *FP17*

BR 07-10-31

12.0 QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

07.10.31 JJ

Job Completion



u 07.10.31

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	34943
Description: Wearpad	Part Number:	D3537-1
Inspection Dwg: D3537	Rev: C	Page 1 of 1

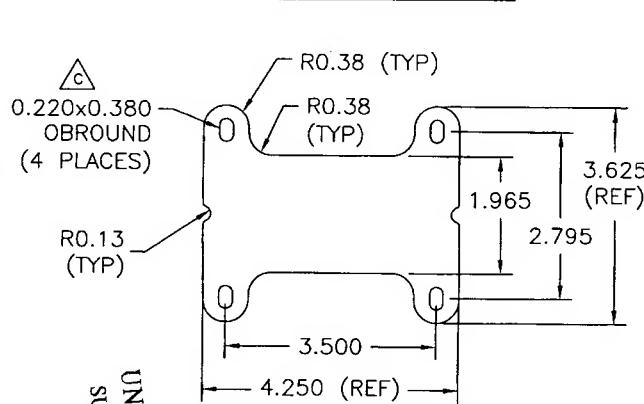
FIRST ARTICLE INSPECTION CHECKLIST

X First Article | Prototype

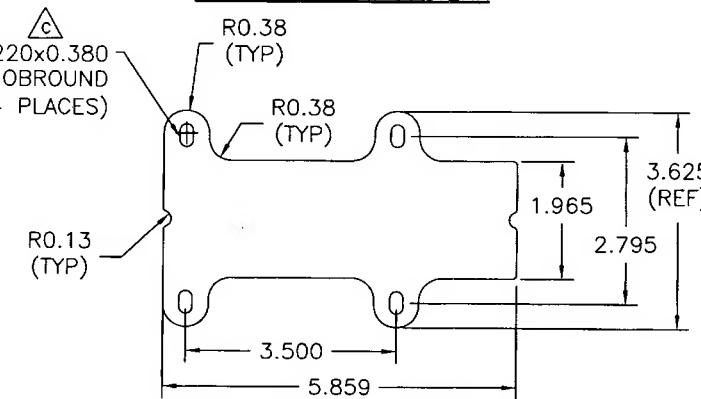
Measured by:	1B	Audited by:	C	Prototype Approval:	N/A
Date:	07-10-9	Date:	07/10/17	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	07.03.21	New Issue	KJ/JLM	
B	07.04.27	Dimensions revised per Dwg Rev. B	KJ/JLM	
C	07.05.28	Dimensions revised per Dwg Rev. C	KJ/JLM	

D3537-1F FLAT PATTERN



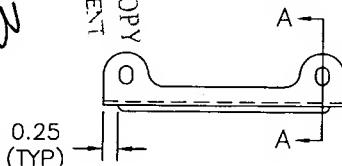
D3537-3F FLAT PATTERN



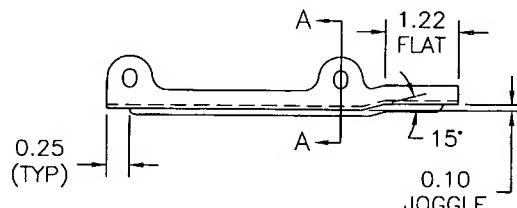
NO. 34914

UNCONTROLLED
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
ENGINEERED
COPY
RETURN TO
SHOP COPY
MADE FROM D3537-1F

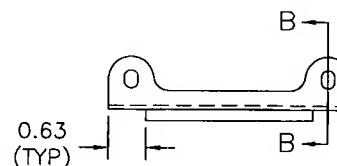
D3537-1 LONGITUDINAL BEND
(MADE FROM D3537-1F)



D3537-3 LONGITUDINAL BEND
(MADE FROM D3537-3F)



D3537-5 LONGITUDINAL BEND
(MADE FROM D3537-1F)



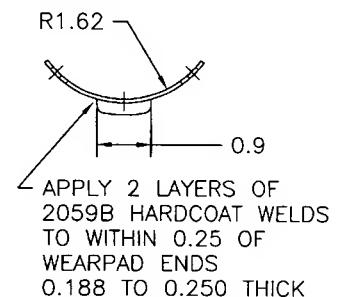
D3537-1/-3/-5/-7 WEARPAD NOTES

- 1) MATERIAL: AISI 304/316 SS SHEET PER AMS 5513 OR AMS 5524, 16 GAUGE (0.063 THICK)
(REF DART SPEC. M304S16GA)
- 2) BREAK ALL SHARP CORNERS 0.063 MAX
- 3) WELD PER QSI 004
- 4) FINISH: POWDER COAT GREY SANDEX (4.3.5.6) PER QSI 005 4.3
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) ALL DIMENSIONS ARE IN INCHES

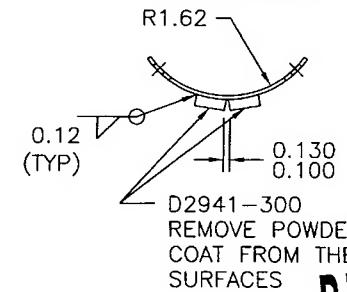
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SECTION A-A

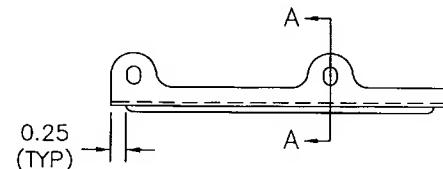


SECTION B-B



RELEASED
07.05.08 A#
per ECN
952

D3537-7 LONGITUDINAL BEND
(MADE FROM D3537-3F)



C	07.04.13	WIDEN TAB TO 0.380, WELD PATTERN
B	07.03.20	ADD AMS 5513 AND AMS 5524
A	06.11.06	NEW ISSUE
DESIGN	DRAWN BY	DART AEROSPACE USA, INC. PORT HADLOCK, WA.
CB	PH	REV. C
CHECKED	APPROVED	DRAWING NO. D3537
DATE	TITLE	SCALE 1:2
07.04.13	WEARPAD	